

6061-T6 Alu. R.O.625"

Work Order ID 74869

74869

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October 13, 2011 10:36:02 AM

Item ID: D2594-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plug, 205 Skidtube

Start Date: 10/13/11 Start Qty: 200.00

200

Cust Item ID:

Required Date: 10/27/11 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/10/14

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2594

Rev C

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262.2-Break all sharp edges 0.010 max.

200 ϕ 11/10/27

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

200 ϕ 11/10/27

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A 11/10/28

200 ϕ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74869

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October 13, 2011 10:36:02 AM

Item ID: D2594-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plug, 205 Skidtube
 Start Date: 10/13/11 Start Qty: 200.00 ***200*** Cust Item ID:
 Required Date: 10/27/11 Req'd Qty: 200.00 ***200*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:10								
	FINISH TIME: 3200F								
	OVEN TEMPERATURE: 9:40								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

200 BL 11-1-1

200X M-1 11/12/01

200 BL 11-12-1

W 118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 74869

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October 13, 2011 10:36:02 AM

Item ID: D2594-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Plug, 205 Skidtube
 Start Date: 10/13/11 Start Qty: 200.00 ***200*** Cust Item ID:
 Required Date: 10/27/11 Req'd Qty: 200.00 ***200*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>FPA</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

200X M-11/12/01

11/12/5

11-12-02
(200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2011 10:36:07 AM

Page 1

Work Order ID: 74869

74869

Parent Item: D2594-1

D2594-1

Parent Item Name: Plug, 205 Skidtube

Start Date: 10/13/11

Required Date: 10/27/11

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP D02.08.22Make in CobraKJ
IPP E 06.12.11 ecn 836 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6R0.625

Purchased

No

110

f

0.1840

0.0521

10.96842

M6061T6R0 625

**

12.666

PLU/10/27

6061-T6 Round Bar .625"

Location

Loc Qty

Loc Code

MAT012

0.184

117284

0.184

119346

12.666

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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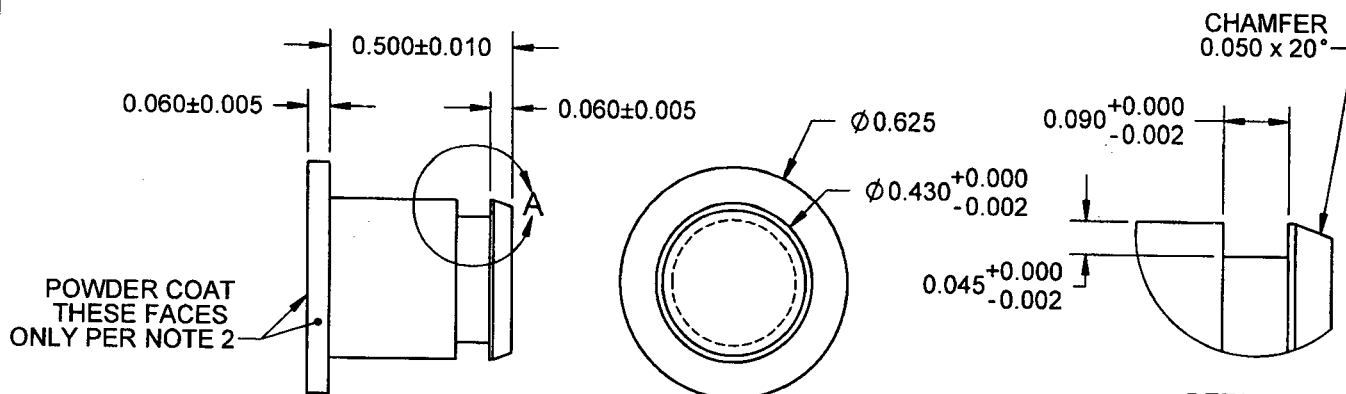
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG SCALE 2:1	
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
06.11.28



D2594-1 PLUG

D2594-1 PLUG NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

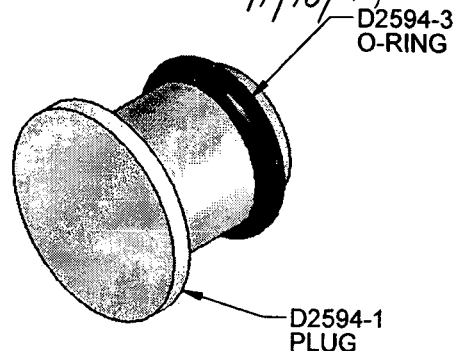
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74869
11/16/14

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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